

Work Order ID 111312

January-10-14 1:05:56 PM

D4617-045
B111312

111312

Page 1

Item ID: D4617-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp Assembly
 Start Date: 1/10/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/24/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-01-10 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4617	B								
100	Pick Kit	0.00							
100						2			FF 23-01-14
Packaging	Memo	0.00							
Packaging									
110		0.00							
110						2			FF 23-01-14
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							
120						2			
QC	Memo	0.00							
Quality Control									

DAS
27
1-89

14/1/23

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Page 2

Item ID: D4617-045 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Clamp Assembly

Start Date: 1/10/14 Start Qty: 2.00 *2* Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST247A</u>	0.00							
130									
Packaging	Memo	0.00				2x	DAS 28 9-89	14-01-23	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-01-27

(H) 14-01-24

Picklist Print

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Work Order ID: 111312

111312

Parent Item: D4617-045

D4617-045

Parent Item Name: Clamp Assembly

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.04.13 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4617-5		Manufactured	No			100	Each	4.0000	1	2			
D4617-5									**		FF	23-01-14	
Clamp Body													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST114		4							
					107002	4				<u>2</u>			
D4617-7		Manufactured	No			100	Each	0.0000	1	2			
D4617-7									**		2 FF	23-01-14	
Clamp Half													
AN4-14A		Purchased	No		110902	100	Each	378.0000	3	6			
AN4-14A									**		FF	23-01-14	
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		5							
					122141	5							
				ST515		373				<u>6</u>			
					M127044	123							
					M127815	250							
AN960-416	NAS1149F0463P	Purchased	No				Each	0.0000		10			
AN960-416									**	10	FF	23-01-14	
STEEL WASHER													
MS21044N4		Purchased	No			100	Each	51.0000	3	6			
MS21044N4									**		FF	23-01-14	
Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST315		51				<u>6</u>			
					m126254	51							

Picklist Print

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Page 2

Work Order ID: 111312

111312

Parent Item: D4617-045

D4617-045

Parent Item Name: Clamp Assembly

Start Date: 1/10/14

Required Date: 1/24/14

Start Qty: 2.00

Required Qty: 2.00

MS22034-4

Purchased

No

100

Each

8.0000

1

2

MS22034-4

Quick Disconnect Adapter

FF 23-01-14

Location

Loc Qty

Loc Code

ST323

8

121662

1

124186

7

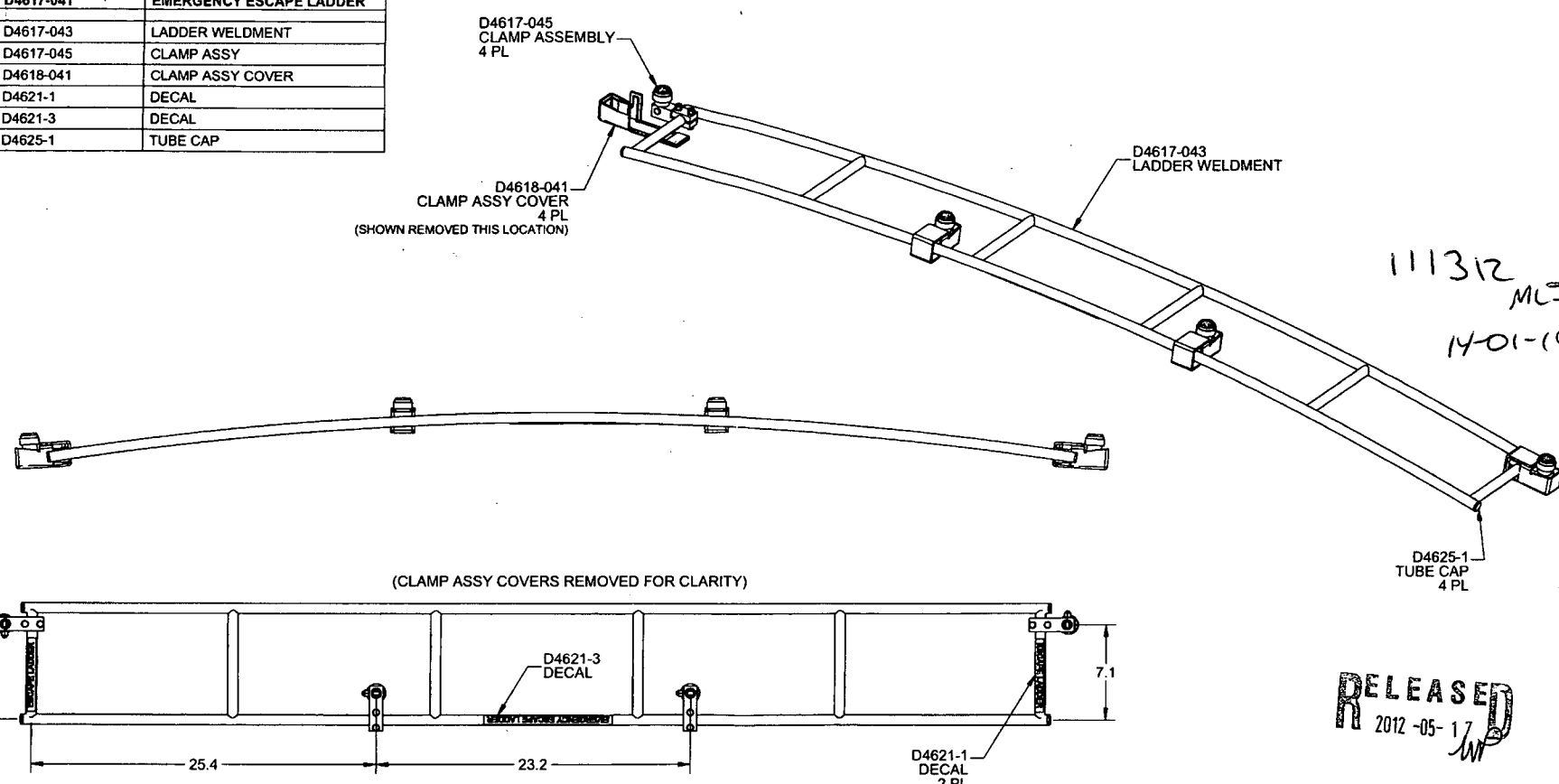
2

January-10-14 1:06:00 PM

Shop Packet Print

Page 2

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP

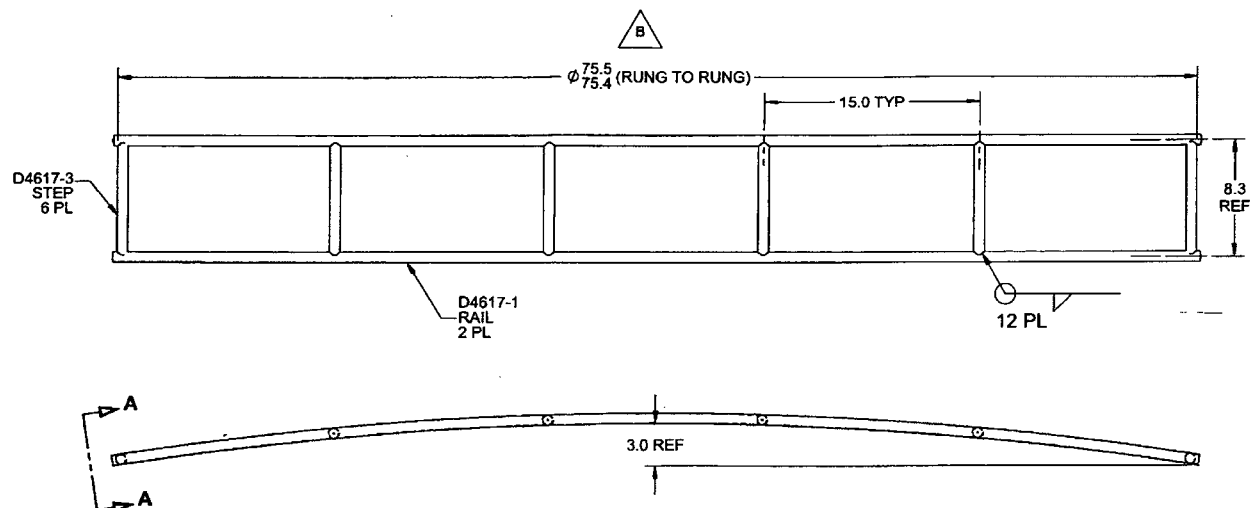
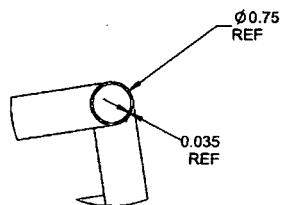


D4617-041 EMERGENCY ESCAPE LADDER

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
 - 7) WEIGHT: 6.48 lbs

B	75.4-75.5 WAS 75.7 (C4-2) WASHER WAS NAS1149C0463R, QTY 3 ON SHT 4. 0.753-0.756 WAS 0.750-0.753 (B4-5)	RP	12.05.01
A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP		
DRAWN	RP		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.05.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4617	REV. B
TITLE EMERGENCY ESCAPE LADDER	SHEET 1 OF 5
SCALE NTS	
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D4617-043 LADDER WELDMENT

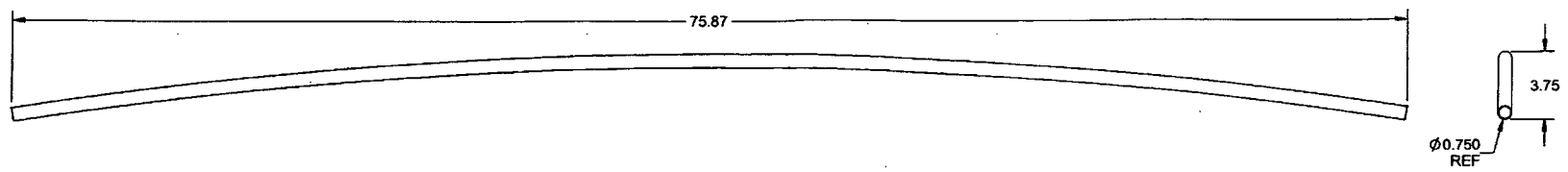
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2012-05-17

NOTES:

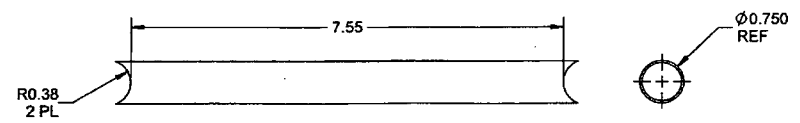
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 4.5 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO. D4617	REV. B
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8 7 6 5 4 3 2 1



D4617-1 RAIL



D4617-3 STEP

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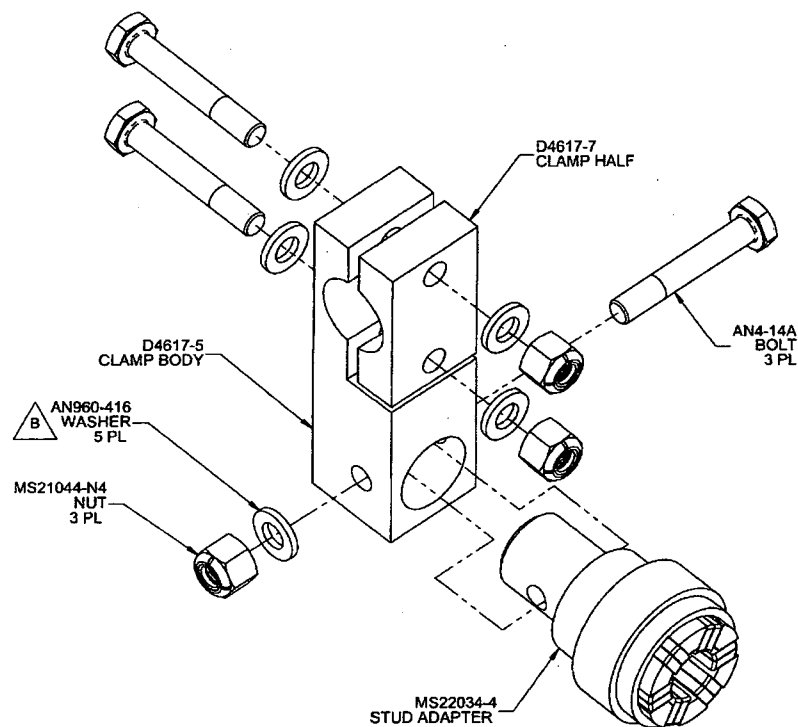
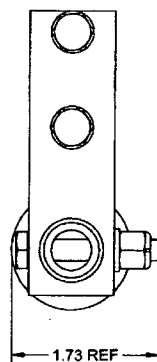
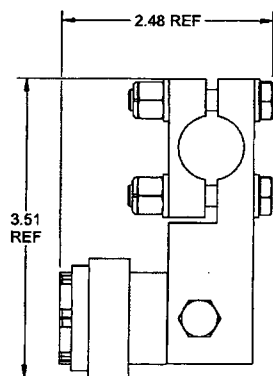
NOTES:

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T6736
OR AMS6371, 6360, 6361, 6362, 6373, 6374
REF DART SPEC M4130NT0.750W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: D4617-1 1.7lbs
D4617-3 0.17lbs

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CHECKED	A.P.	DRAWING NO. D4617	REV. B
MFG. APPR.		SHEET 3 OF 5	
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DE APPR.		EMERGENCY ESCAPE LADDER	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D4617-045	CLAMP ASSEMBLY
1	1	D4617-5	CLAMP BODY
2	1	D4617-7	CLAMP HALF
3	3	AN4-14A	BOLT
4	5	AN960-416	WASHER
5	3	MS21044-N4	NUT
6	1	MS22034-4	STUD ADAPTER






D4617-045 CLAMP ASSY

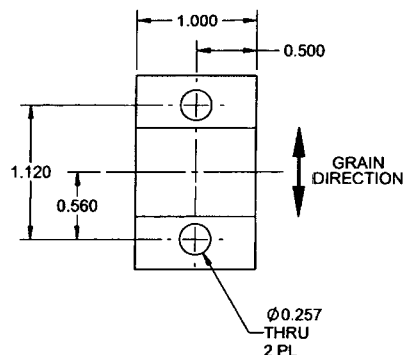
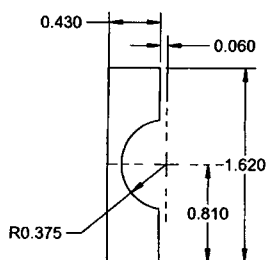
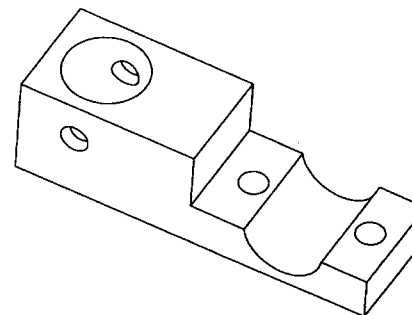
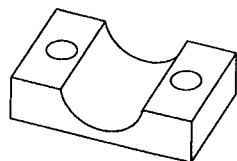
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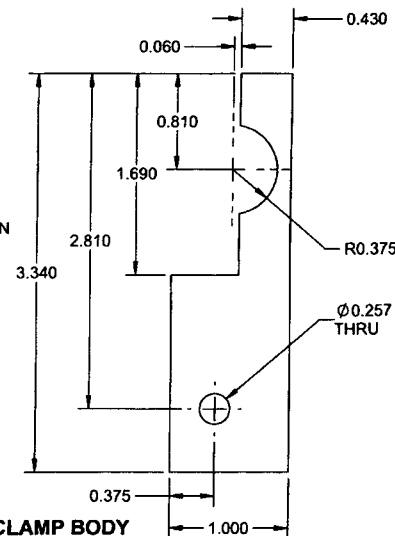
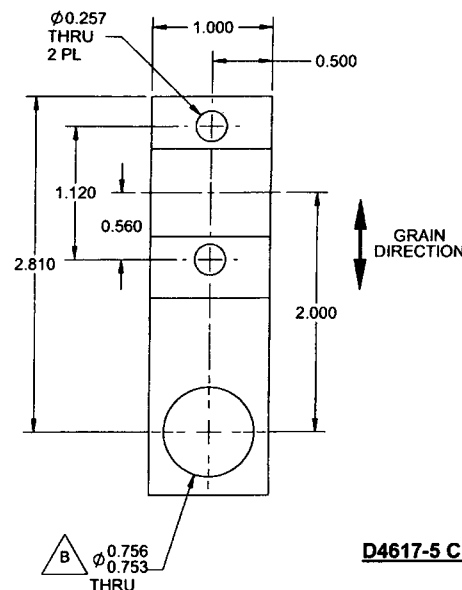
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 0.5 lbs

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DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4617	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		EMERGENCY ESCAPE LADDER	NTS
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8 7 6 5 4 3 2 1



D4617-7 CLAMP HALF



D4617-5 CLAMP BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS 4117/4128/4115/4116 OR QQ-A-200/8
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: D4617-5 0.17 lbs
D4617-7 0.05 lbs
- 8) POSSIBLE SUPPLIER: D4617-5: EAGLE P/N 212-110-06
D4617-7: EAGLE P/N 212-110-07

RELEASED
2012-05-17

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DRAWN	RP		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4617	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 5 OF 5
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DE APPR.	<i>[Signature]</i>	EMERGENCY ESCAPE LADDER	
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